

slip 28/06

Work Order ID 85540

\*85540\*

Page 1

June-11-12 9:53:55 AM

Item ID: D119-646-243

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Float Skidtube w/ Training Wearplates

Stop \*NS2\*

Start Date: 08/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3905	B
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D3905-045,-13	B
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IIN-D119-646	B
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100	0.00
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\*100\*

DC	0.00
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Document Control	Memo Photocopy bluefile & type labels per PPP D119-646-243 CHG 001
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N/A

110	0.00
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\*110\*

Skidtubes	0.00
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Skidtubes	Memo 1- Inspect Mat'l D2500-1-190 for damage
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2- Ensure squareness of ends

De 12/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 85540

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Item ID: D119-646-243

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*120*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill								
	2- Scribe batch # inside aft end of tube								

1 7/16 12-6-12

① Ø DC 12/06/13

DC 12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

0.00

**\*155\***

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end.

2- Esure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

*DE 12/06/14*

165

QC5- Inspect part completeness to step on W/O

0.00

**\*165\***

QC

Quality Control

Memo

0.00

*DP 12-6-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 85540****\*85540\***

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Item ID: D119-646-243

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00

**\*180\***

Skidtubes

Skidtubes

Memo

0.00

1- Verify dimention of bend as per dwg D3905

2- Buff out marks left from bending.

3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, open to finished size

4- Drill Aft wearplate and wearpad holes using DT9546 and DT9545 as per dwg D3905 detail G open to finished size

5- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E)  
\*\*\*DO NOT OPEN FWD SADDLE HOLES\*\*\*

6- Deburr, blow out chips from inside of tube

7-Bond web in place as per Dwg D3905 &amp; QSI 015.

A/RSikaflex-291 12/409Sikaflex expire date: 13-4-12Start: 12/06/18Time: 9:20Finish: 12-06-20Time: 11:00

\*\*\*\*\* (Adhere for 12 hours) \*\*\*\*\*

DC 12/06/18

DC 12/06/18

- DC 12/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 08/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 QC5- Inspect part completeness to step on W/O 0.00

\*190\*

QC Memo 0.00

Quality Control

*DP* 12-6-19

200 0.00

\*200\*

CNC Bend 1 Memo 0.00

CNC Delta 100 Bender

1- Bend Fwd end of tube using bender 1 and bend prog. D3905 Fwd. Use bending aid DT9544 ensure proper positioning

2- Cut Fwd end of tube as per dwg.

\*\*\*VERIFY MEASUREMENT BEFORE CUTTING\*\*\*

*DC* 12/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

0.00

**\*210\***

Skidtubes

Skidtubes

Memo

0.00

~~/~~ Buff out marks left from bending~~/~~ Drill Fwd cap holes using DT8215. Open Fwd and Aft cap holes to 0.208"~~/~~ Open Fwd saddle holes to finished size as per dwg~~/~~ Drill Fwd x-bolt hole and open to finished size. (Holes must be laid out manually)~~/~~ Drill trowing hole and open to finished size. (Holes must be laid out manually)~~/~~ Open Aft float holes 0.391" as per dwg D3905 detail G and section F-F~~/~~ Deburr, blow out chips from inside of tube.1 ~~/~~ CF 12/6/20

220

QC5- Inspect part completeness to step on W/O

0.00

**\*220\***

QC

Quality Control

Memo

0.00

1 ~~/~~ BE 12/26/20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 85540****\*85540\***

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June-11-12 9:53:55 AM

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Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

224

0.00

**\*224\***

Skidtubes

Memo

0.00

1- Countersink x-bolt holes as per dwg

2- Remove alodine prepare for welding

3- Insert x-bolt spacers

4- Weld x-bolt spacer as per dwg

A/R Alum rod Batch: M12064

5- Grind welds flush as per dwg

6- Counter bore x-bolt holes as per dwg

7- Deburr

225

QC5- Inspect part completeness to step on W/O

0.00

**\*225\***

QC

Memo

0.00

Quality Control

*> CF 12-6-20**> BE 12-06-20**-> CF 12-6-21**> BE 12-06-21**1 / 12-06-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Float Skidtube w/ Training Wearplates

Stop \*NS2\*

Start Date: 08/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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226	QC10- Inspect visual per QSI004- ground welds	0.00							
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\*226\*

QC Memo 0.00

Quality Control

227	Pressure Wash per QSI005 4.3	0.00							
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\*227\*

HandFinish Memo 0.00

Hand Finishing

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
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\*240\*

Powdercoat Memo 0.00

Powder Coating

M120 200

10:40  
300°  
11:10.

QC 120602

1 26 12-6-22

1 0 12-6-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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June-11-12 9:53:55 AM

Item ID: D119-646-243

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

245

QC3- Inspect Part Finish

0.00

**\*245\***

QC

Memo

0.00

Quality Control

1 x 12/06/26

250

0.00

**\*250\***

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D3905.

1 12/06/26

260

QC5- Inspect part completeness to step on W/O

0.00

**\*260\***

QC

Memo

0.00

Quality Control

5/12/06/26

12/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00

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Cust Item ID:

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**\*1\***

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Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00

**\*270\***

HandFinish

Hand Finishing

Memo

0.00

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers

A/RSikaflex-240/-291

121 404

Sikaflex expire date:

13/07

2- install plugs assembly as per dwg.

3 -Inspect for foreign objects as per QSI 024

4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-240/-291

121 404

Sikaflex expire date:

13/071 27 12/06/2012

280

QC5- Inspect part completeness to step on W/O

0.00

**\*280\***

QC

Quality Control

Memo

0.00

5/12/07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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285	Wing Walk as per dwg QSI005 4.4 Batch <u>121 123</u>	0.00							
-----	--	------	--	--	--	--	--	--	--

\*285\*

HandFinish

Memo

0.00

Hand Finishing

1 2 28 12/06/29.

286	QC3- Inspect Part Finish	0.00							
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\*286\*

QC

Memo

0.00

Quality Control

ik 12-7-13.

290	Identify as per dwg & Stock Location: _____	0.00							
-----	---	------	--	--	--	--	--	--	--

\*290\*

Packaging

Memo

0.00

Packaging

Pro 87090

12/11/13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC21- Final Inspection - Work Order Release	0.00							
<b>*300*</b>									
QC	Memo	0.00							
Quality Control									

12/7/18  
mf  
12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 85540

**\*85540\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-1-190

Manufactured

No

110

Each

85.0000

1

1

**\*D2500-1-190\***

Ext'n - I' Beam Tube 4"

\*\*

De 12/06/12

Location

Loc Qty

Loc Code

HALL

85

74777

12

80061

73

D3885-3

Manufactured

No

170

Each

10.0000

1

1

**\*D3885-3\***

Standard Web

\*\*

De 12/06/18

Location

Loc Qty

Loc Code

LG

10

52425

10

D3903-1

Manufactured

No

190

Each

70.0000

12

12

**\*D3903-1\***

Spacer

\*\*

De 12/06/20

Location

Loc Qty

Loc Code

LG

40

74876

40

LG001

30

78790

30

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 85540

**\*85540\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3681-1

Manufactured No

190

Each

53.0000

8

8

**\*D3681-1\***

Spacer

**\*\***

*BE 12/06/20*

Location

Loc Qty

Loc Code

LG

43

80361

1

84053

42

*B*

LG001

10

68958

2

69893

2

71845

2

74874

1

76004

1

77501

2

D3683-3

Purchased No

250

Each

586.0000

12

12

**\*D3683-3\***

Insert

**\*\***

*12*

*28*

*12/06/26*

Location

Loc Qty

Loc Code

FP002

26

47805

26

ST060

560

47805 ✓

560

NO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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June-11-12 9:53:59 AM

Page

Work Order ID: 85540

**\*85540\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

1,973.000

10

10

**\*AI S4-1032-130\***

Insert

\*\*

10 (2P) 12/06/26

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

44

120807

36

120837

8

ST282

1724

121269 ✓

1724

D2855-3

Manufactured

No

270

Each

22.0000

2

2

**\*D2855-3\***

Cap

\*\*

2 (2P) 12/06/26

Location

Loc Qty

Loc Code

FP002

22

52281

7

75080 ✓

15

D3672-1

Manufactured

No

270

Each

1,530.000

4

4

**\*D3672-1\***

Phenolic Washer

\*\*

4 (2P) 12/06/26

Location

Loc Qty

Loc Code

ST060

1530

72229

4

76277

20

80369 ✓

496

83608

500

85222

510

# WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-11-12 9:53:59 AM

Page

Work Order ID: 85540

**\*85540\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3846-1	Manufactured	No	270	Each	36.0000	1	1	
<b>*D3846-1*</b>						**	1	SP 12/06/26
GASKET								

Location	Loc Qty	Loc Code
FP002	36	
51827	4	
53735 ✓	32	

D3846-11	Manufactured	No	270	Each	13.0000	1	1	
<b>*D3846-11*</b>						**	1	SP 12/06/26
GASKET								

Location	Loc Qty	Loc Code
FP002	13	
51833 ✓	13	

D3847-1	Manufactured	No	270	Each	11.0000	1	1	
<b>*D3847-1*</b>						**	1	SP 12/06/26
WEARPAD								

Location	Loc Qty	Loc Code
FP002	11	
51823	11	

D3847-11	Manufactured	No	270	Each	15.0000	1	1	
<b>*D3847-11*</b>						**	1	SP 12/06/26
WEARPAD								

Location	Loc Qty	Loc Code
FP002	15	
51824	15	

D3849-047	Manufactured	No	270	Each	0.0000	1	1	
<b>*D3849-047*</b>						**	1	SP 12/06/26
WEARPLATE								

85543 ✓

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-11-12 9:53:59 AM

Work Order ID: 85540

**\*85540\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3849-045

Manufactured No

85342✓

270

Each

0.0000

1

1

**\*D3849-045\***

AFT WEARPLATE ASSY, FLOAT GEAR

D3904-1

Manufactured No

270

Each

177.0000

16

16

**\*D3904-1\***

Washer

\*\*

1 (2P) 12/06/29

\*\*

16 (2P) 12/06/26

## Location

## Loc Qty

## Loc Code

ST068

177

51875✓

177

D3672-3

Manufactured No

270

Each

583.0000

12

12

**\*D3672-3\***

Phenolic Washer

\*\*

12 (2P) 12/06/26

## Location

## Loc Qty

## Loc Code

ST060

583

84361✓

583

AN3C5A

Purchased No

270

Each

1,274.000

14

14

**\*AN3C5A\***

Bolt

\*\*

14 (2P) 12/06/26

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

1267

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255✓

500

121444

154

121708

500

June-11-12 9:53:59 AM

Shop Packet Print

Page 5

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

June-11-12 9:53:59 AM

Work Order ID: 85540

Parent Item: D119-646-243

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

\*85540\*

\*D119-646-243\*

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

270

Each

43.0000

4

4

\*AN3C46A\*

BOLT

\*\*

4

(28)

12/06/2012

Location

Loc Qty

Loc Code

ST355

43

120447✓

43

AN960C10L

4

NAS1149C0332✓

Purchased

No

270

Each

21.0000

10

10 14

\*AN960C10I \*

washer

122063✓

\*\*

14

(28)

12/06/2012

Location

Loc Qty

Loc Code

ST

21

107534

21

AN960C416

4

NAS1149C0463✓

Purchased

No

270

Each

0.0000

12

12

\*AN960C416\*

washer

119097✓

\*\*

12

(28)

12/06/2012

MS21043-3

Purchased

No

270

Each

1,439.000

8

8

\*MS21043-3\*

Nut

\*\*

8

(28)

12/06/2012

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1367

118077

2

118614

51

118686

30

119758

20

121255

270

121708✓

994

June-11-12 9:53:59 AM

Shop Packet Print

Page 6

## WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

June-11-12 9:53:59 AM

Work Order ID: 85540

**\*85540\***

Parent Item: D119-646-243

**\*D119-646-243\***

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039C4-08

Purchased

No

270

Each

98.0000

12

12

**\*MS27039C4-08\***

SCREW

\*\*

12

(2P)

12/06/26

Location

Loc Qty

Loc Code

FP002

7

17831

7

ST293

91

114721✓

91

AN3C50A

Purchased

No

270

Each

78.0000

4

4

**\*AN3C50A\***

Bolt

\*\*

4

(2P)

12/06/26

Location

Loc Qty

Loc Code

ST355

78

112761

20

114442✓

33

120447

25

D3411-3

Manufactured

No

270

Each

58.0000

16

16

**\*D3411-3\***

WASHER

\*\*

16

(2P)

12/06/26

Location

Loc Qty

Loc Code

ST042

58

51635✓

17

55317✓

41

1  
15

## WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

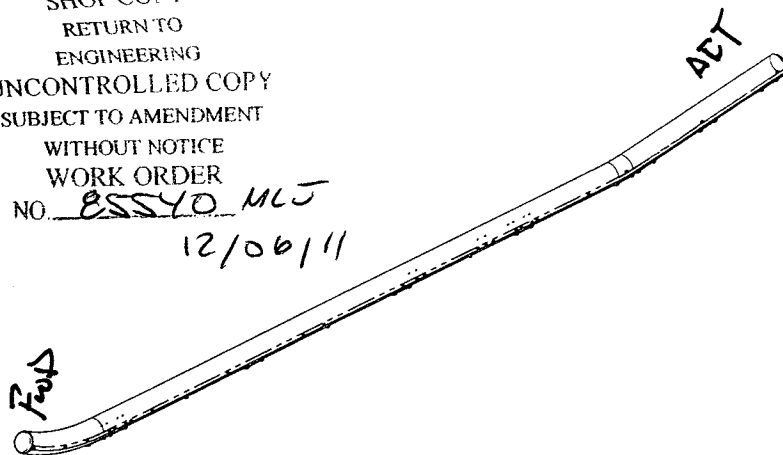
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85540 MLJ  
12/06/11



**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)**  
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs  
D3905-043 = 47.0 lbs  
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES  
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT  
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT  
PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE  
WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS.  
INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS  
WITH SIKAFLEX-241/291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLA
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

RELEASED  
12/15/11

REVISED PART LIST: ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A5-6, C5-7, C1-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-6); REVISED NOTE IV (ZN A8-7)		RF	09.06.30
NEW ISSUE		RF	09.03.30
DESIGN	RF	DESCRIPTION	
DRAWN	RF	DART AEROSPACE USA, INC.	
CHECKED	RF	PORT HADLOCK, WA	
MFG. APPR.	RF	DRAWING NO.	REV. B
APPROVED	RF	D3905	SHEET 1 OF 8
DE APPR.	RF	TITLE	SCALE
DATE	09.06.30	A119 FLOAT SKIDTUBE ASSY	NTS

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## WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

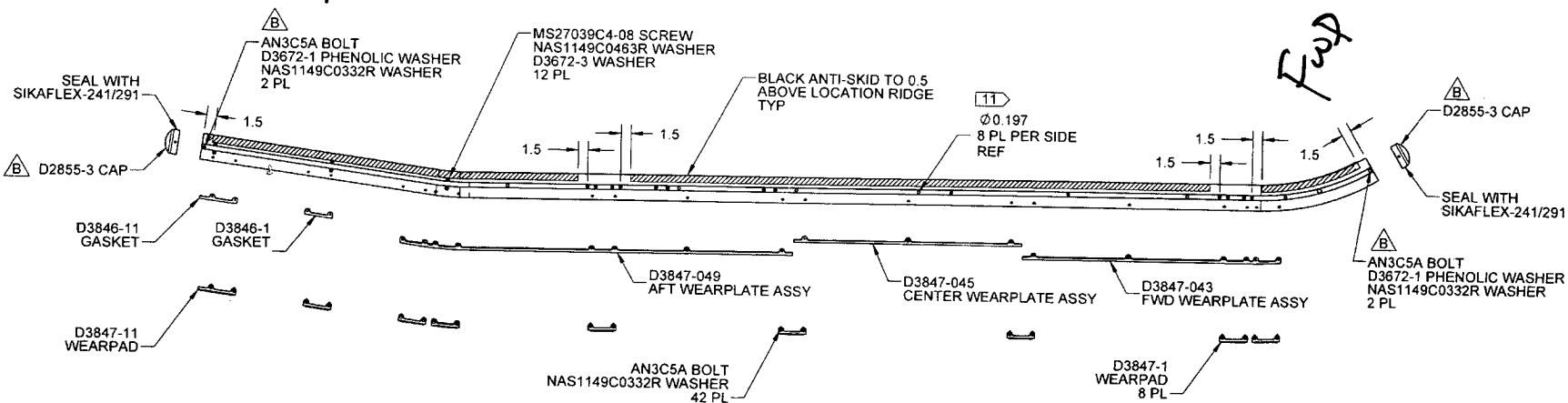
NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE**  
(MAKE FROM D3905-11 SKIDTUBE)

RELEASED  
09/07/15 JAP

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO. <b>D3905</b>	REV. B
MFG. APPR.	RF	SHEET 3 OF 8	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>A119 FLOAT SKIDTUBE ASSY</b>	NTS
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## WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SEAL WITH  
SIKAFLEX-241/291

D2855-3 CAP

D3846-11 GASKET

D3847-11  
WEARPAD

AN3C5A BOLT  
NAS1149C0332R WASHER  
10 PL

AN3C5A BOLT  
D3672-1 PHENOLIC WASHER  
NAS1149C0332R WASHER  
(1 PER SIDE)

MS27039C4-08 SCREW  
NAS1149C0463R WASHER  
D3672-3 WASHER  
12 PL

BLACK ANTI-SKID TO 0.5  
ABOVE LOCATION RIDGE  
TYP

D2855-3 CAP

SEAL WITH  
SIKAFLEX-241/291

AN3C5A BOLT  
D3672-1 PHENOLIC WASHER  
NAS1149C0332R WASHER  
2 PL

D3846-1  
GASKET

D3847-1  
WEARPAD

D3849-045  
AFT TRAINING WEARPLATE ASSY

AN3C46A BOLT  
D3904-1 WASHER, 2 PL  
MS21043-3 NUT  
4 PL

D3849-047  
FWD TRAINING WEARPLATE ASSY

AN3C50A BOLT  
D3904-1 WASHER, 2 PL  
D3411-3 WASHER, 4 PL  
MS21043-3 NUT  
4 PL

**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE**  
(MAKE FROM D3905-13 SKIDTUBE)

RELEASED  
09/07/15

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DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 4 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
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## WORK ORDER CHANGES

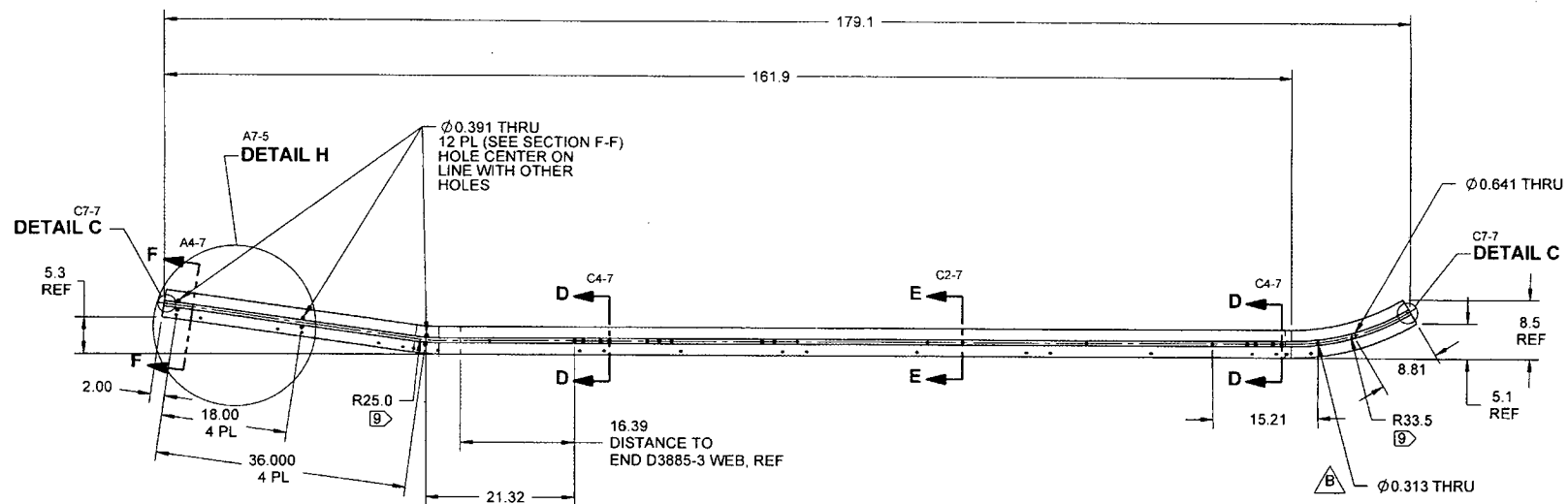
STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

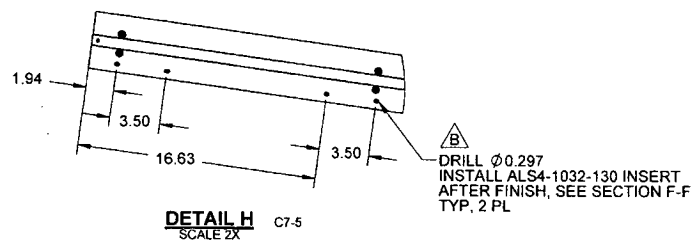
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3905-11 FLOAT SKIDTUBE**  
(MAKE FROM D3905-1 TUBE)



**RELEASED**  
10/17/15

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## WORK ORDER CHANGES

/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

108540

DETAIL G  
A7-6

DETAIL C  
C7-7

5.3  
REF

2.00

F A4-7

F

18.00  
4 PL

36.00  
4 PL

R25.0

21.32

16.39  
DISTANCE TO  
END D3885-3 WEB, REF

D C4-7

D

E C2-7

E

D C4-7

D

15.21

Ø 0.641 THRU

DETAIL C  
C7-7

8.5  
REF

8.81

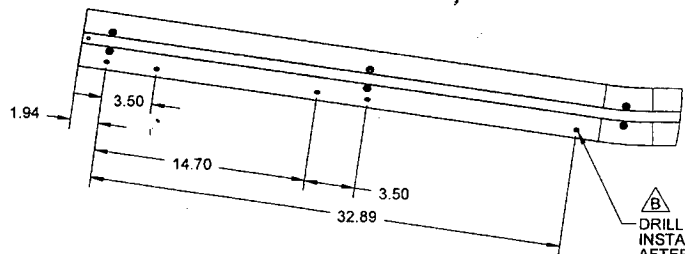
5.1  
REF

R33.5

Ø 0.313 THRU

B

**D3905-13 FLOAT SKIDTUBE**  
(MAKE FROM D3905-1 TUBE)



**DETAIL G**  
SCALE 2X  
C8-6

B  
DRILL Ø 0.297  
INSTALL ALS4-1032-130 INSERT  
AFTER FINISH, SEE SECTION F-F  
TYP, 2 PL

RELEASED  
9/6/15

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

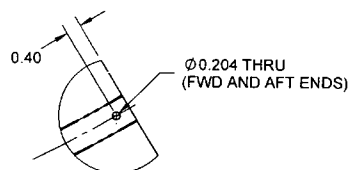
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

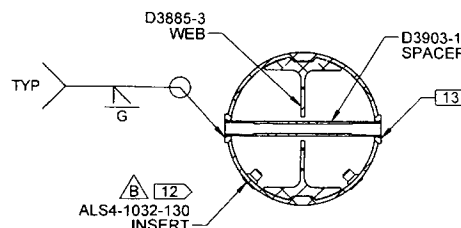
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

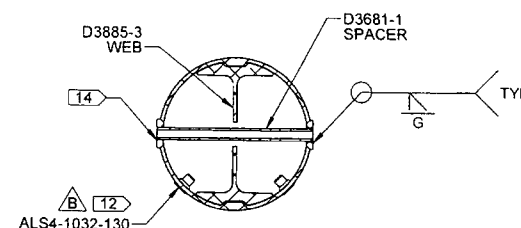




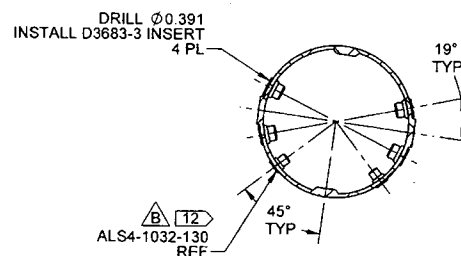
**DETAIL C**  
SCALE 4X  
C1-5  
C8-5  
C8-6  
C1-6



**SECTION D-D**  
SCALE 4X  
(FOR 12 x Ø 0.375 HOLES  
PER SKIDTUBE)  
C5-5  
C2-5  
C5-6  
C2-6



**SECTION E-E**  
SCALE 4X  
(FOR 8 x Ø 0.313 HOLES  
PER SKIDTUBE)  
C4-5  
C4-6  
B



**SECTION F-F**  
SCALE 4X  
C7-6  
C7-5

**NOTES:**

- 13) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø 0.375 HOLES ONLY:  
i) CHAMFER HOLES Ø 0.475 x 45° (BOTH SIDES)  
ii) INSERT D3903-1 SPACER  
iii) WELD INTO PLACE AND GRIND FLUSH  
iv) C'BORE TO 0.313 x 0.75 DEEP  
v) DEBURR HOLES
- 14) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø 0.313 HOLES ONLY:  
vi) CHAMFER HOLES Ø 0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)  
vii) INSERT D3681-1 SPACER  
viii) WELD INTO PLACE AND GRIND FLUSH  
ix) DEBURR HOLES

**RELEASED**  
09/07/15/11P

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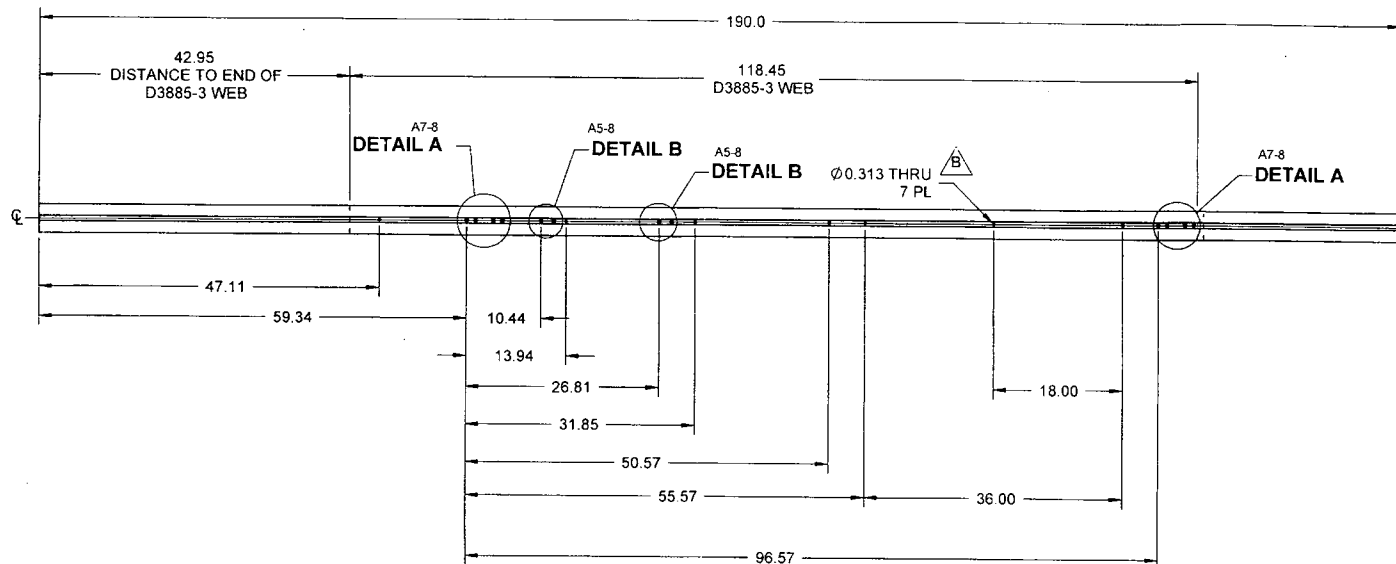
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

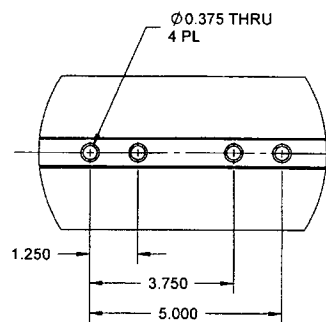
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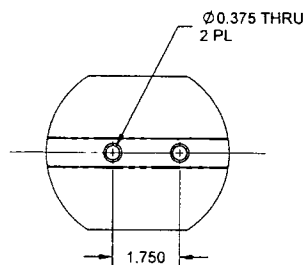
**NOTE:** Date & initial all entries



**D3905-1 TUBE**  
(MAKE FROM D2500-1-190 EXTRUSION)



**DETAIL A**  
SCALE 4X  
D6-8  
D2-8



**DETAIL B**  
SCALE 4X  
D5-8  
D4-8

**RELEASED**  
21/07/15/10

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	RF	DRAWING NO.	REV. B
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APPROVED	RF	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries